Work O	rder ID	72118
Tuesday, Jui	ly 19, 2011	12:38:33
Itom ID:	D2255	5

Quality Control



Page 1

Tuesday, July 19	), 2011 12:38:33 PM		# 3 M M ( FI   L M M M M M M M M M M M M M M M M M M							1 age 1
Revision ID:	D3255-5 Gasket		Accept				S	etup Star Sto		
	7/19/2011 Start Qty: 1 7/25/2011 Req'd Qty: 1			Cust Item I Customer:	D:			·	1 1 <b>8811181 8</b>	(BIB   IS   IS   IS
Approvals:	Process Plan:	Date://-67-/9	7 Tooling: SPC (Y/N):		ate:		R	tun Star Sto		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3255	Rev B									
100  Waterjet  FLOW CNC Waterje	FLOW WATER J  Mem  1-Cut  if nec		0.00  0.00  Prog Rev:   В	□2-Deburr			1B1	-8-17		
110 QC Quality Control	QC2- Inspect part <b>Mem</b>	s off machine FAI/FAIB	0.00				<u> BIC</u>	8-17	(b)	
120    <b>                 </b> QC	QC8- Inspect part		0.00 Su	loz117			417			

W/O:			W	ORK ORDER CHANG	iES		_		
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA	:	Date:	
	R	esolution:	Dispositio	on:	_ QA: N/C C	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC	Initial		ection B  Sign & Section			Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date		n C	Chief Eng	QC Inspector
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							<u> </u>		
•					-				
				•					

#### Work Order ID 72118 Tuesday, July 19, 2011 12:38:33 PM

Page 2

Item ID:

D3255-5

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

**Start Date:** 

Required Date: 7/25/2011

Gasket

7/19/2011

Start Qty: 12.00

**Operation** 

Description

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start



QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty A

Reject Insp. Number Stamp

. 12 1

140

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

0.00

11/108-18 (12)

	-								£
W/O:			W	ORK ORDER CHANC	GES				· ·
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA	۸:	_ Date: _	
	Re	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	ANCE (NC	<b>?</b> )			
DATE	STEP	Description of NC Section A	Initial Chief Eng			& Verification Section C		Approval Chief Eng	Approvai QC Inspector
				5.11.5 Z.1.9	Date		-		
·									

#### **Picklist Print**

Tuesday, July 19, 2011 12:38:39 PM

Work Order ID: 72118

Parent Item:

D3255-5

Parent Item Name: Gasket



Start Date: 7/19/2011

Required Date: 7/25/2011

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

□A□04.05.12□New issue□KJ/RF

IPP Rev:B Now On Waterjet 06-08-14 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255		Manufactured	No			110	sf	40.0000	1.5411	19.46653	1-8-17		
				<b>Location</b>		Loc (	<u>Otv</u>	Loc Code					
				MAT051			3						
				• •	44088		3		_				
				ST412			37						
					63846		37		<u>ک</u>	<u> </u>			

Page 1

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DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	s No DQ	A:	_ Date: _	
		esolution:							
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DALL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC inspector
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									!

DART AEROSPACE LTD	Work Order:	72118
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

	X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	,998	乂		18 04	
18.46	· +/-0.030	18.46	<b>/</b>		4	
11.43	+/-0.030	11.43	8		4	
15.36	+/-0.030	14.36	کے		4	
6.90	+/-0.030	6,90	>		4	
0.063	+/-0.010	,060	6	·	V 1262	
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		1.4.				
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					1.1	-
		-				

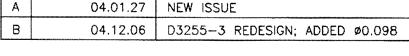
ĺ	Measured by:	Audited by:	Prototype Approval:	N/A
	Date: (1-8-1-7	Date: 4 (08/12	Date:	N/A

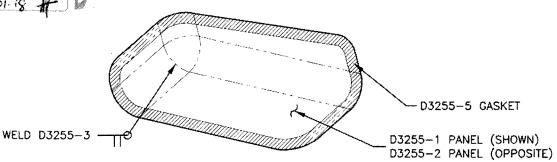
Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue	KJ/JLM	R
			77	

W/O:		- 1122	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			Pair - Adap Rose Add						
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Ye	es No I	DQA:	_ Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C	Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (N	CR)			,
DATE	STEP	Description of NC				Ve	rification	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		n & (	Section C	Chief Eng	QC Inspector
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DESIG	N TH	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CANADA			
CHEC	CED /O	APPROVED	DRAWING NO.	***************************************	REV.	В
	41	-	D3255	SHEET	1 OF	4
DATE	<del>Mik adamaka, Maria a</del>		TITLE	***************************************	SCA	LE
04.1	2.06		ACCESS PANEL ASSEMBLY		1	:6
Α		04.01.27	NEW ISSUE			

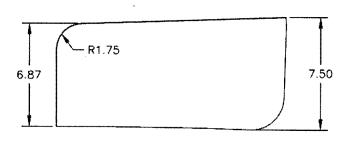


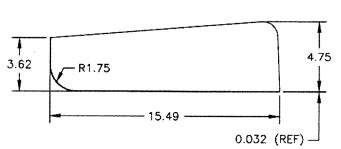


#### D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)

R1.75

(REF)





D3255-1 BEND DETAIL D3255-2 OPPOSITE

# - 0.032 (REF) SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

p111.07-19

#### D3255-041/-042 NOTES:

WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

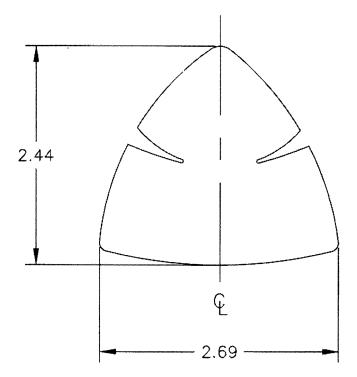
<b>D</b> uit 710	Johaco	Lu		,							
W/O:			W	ORK ORDER CHANGI	ES	· · · · · · · · · · · · · · · · · · ·					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Approval Chief Eng / Prod Mgr	hief Eng /				
							<u> </u>				
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _			
Resolution:			Disposition	on:	QA: N/C CI	A: N/C Closed: Date:					
NCR:		•	WORK ORD	ER NON-CONFORMA	NCE (NCR	(1)					
DATE	STEP	Description of NC		on B	Verifi	cation	ation Approval	Approval			
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C		QC Inspector		
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<sup>·</sup> NOTE: Date & initial all entries



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1 91	1 -	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





12118

# D3255-3 CAP FORM TO FIT D3155-1/-2

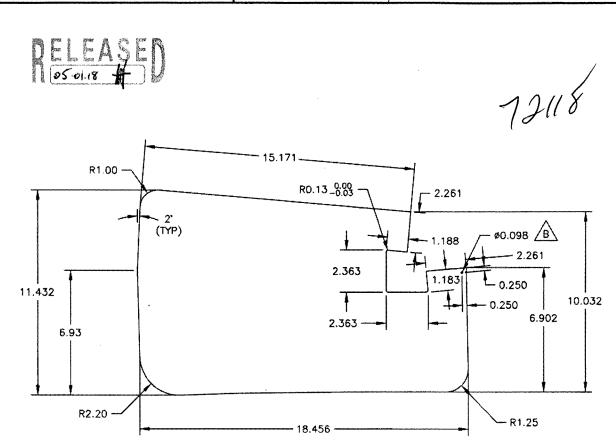
#### D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

	- CP - C			·					
W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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NCR:		,	WORK ORDI	ER NON-CONFORMAI	NCE (NC	R)			
DATE	STEP	Description of NC	·····	Corrective Action Section		Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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W.	1 #	D3255	SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5



# D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

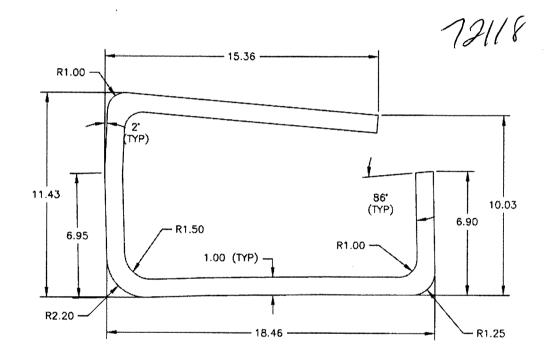
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





#### D3255-5 GASKET

<u>D3255-5 NOTES:</u>
1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

W/O:	-		WC	ORK ORDER CHANG	iES			, ,		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ē	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo <b>DQ</b>	A:	Date: _	·
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (I	NCR)				
DATE	STEP	Description of NC			tion B		Verific	cation	Approval	Approval QC Inspector
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section C		Chief Eng	QC Inspector
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